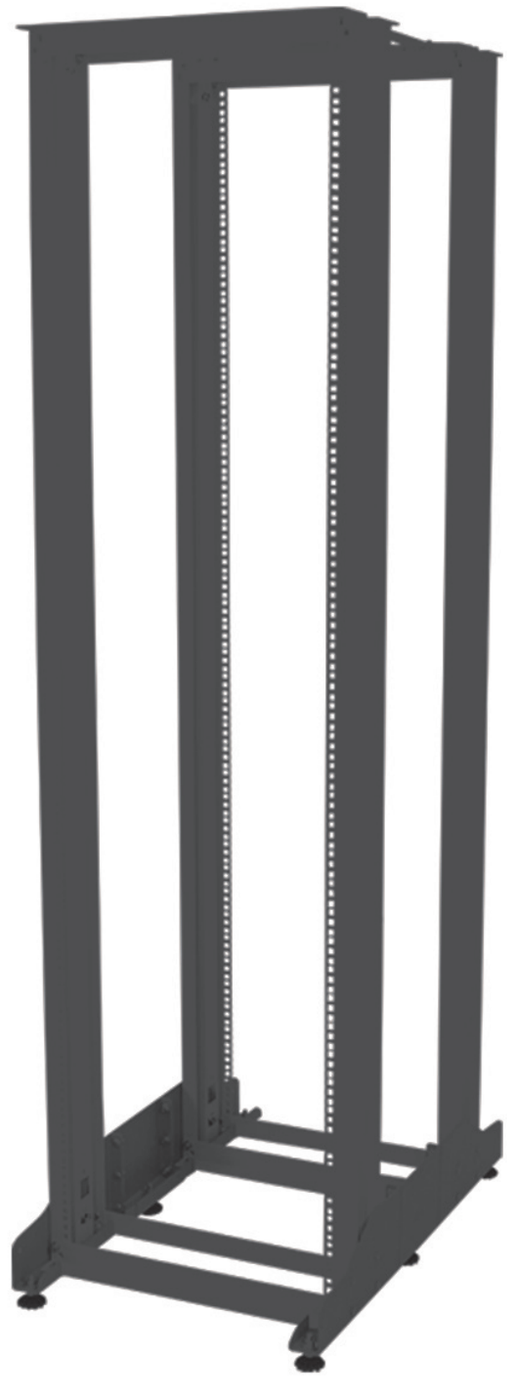
DOUBLE-FRAME RELAY RACK
ASSEMBLY INSTRUCTIONS



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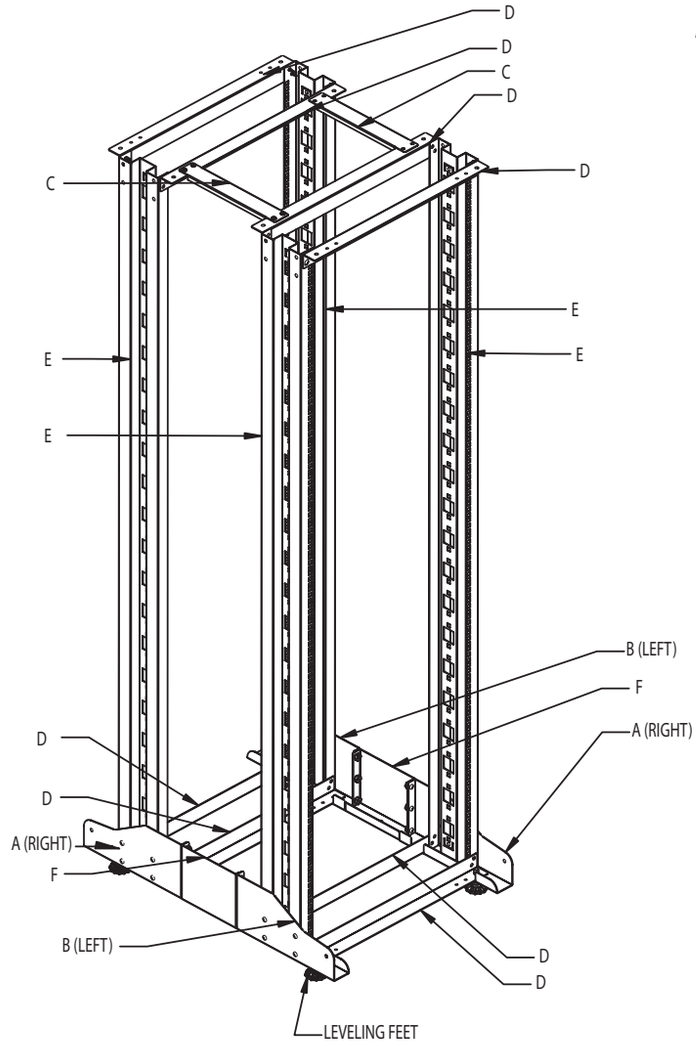
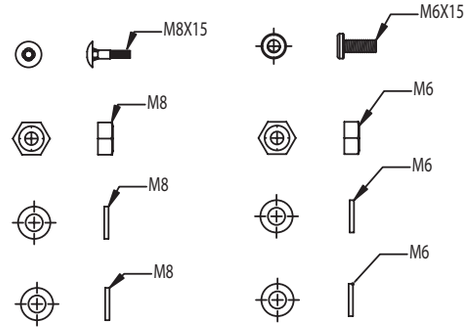
Double Rack Parts List



ASSEMBLY HARDWARE



TOLERANCE						ISO 2768-m
Basic dimension		Deviation		Shorter side		Deviation
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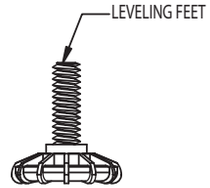
0.5	3	±0.1	±0.2	-	10°	±1°
3	6	±0.1	±0.5	10°	50°	±0°30'
6	30	±0.2	±1	50°	120°	±0°20'
30	120	±0.3	±1	120°	400°	±0°10'
120	400	±0.5	±1	400°	-	±0°5'
400	1000	±0.8	±1			
1000	2000	±1.2	±1			

PART NO.	PART DESCRIPTION	QUANTITY INCLUDED
A	Base, Right Side	2
B	Base, Left Side	2
C	Vertical Support	2
D	Horizontal Support	8
E	Vertical Rack Rail	4
LEVELING FEET	Leveling Feet	4
F	Extension Kit	2
M8X15	Channel Screw	66
M8	Nut	66
M8	Washer	66
M8	Spring Washer	66
M6X15	Screw	8
M6	Nut	8
M6	Washer	8
M6	Spring Washer	8



REV				
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ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	QTY. RQD.
PARTS LIST				
MATERIAL: CRS1110 (A1) FINISH				
CAD-GENERATED DRAWING DO NOT MANUALLY UPDATE				
DO NOT SCALE DRAWING				

APPROVALS	DATE	SIZE	DWG NO.	SHEET OF	REV
DRAWN					00
CHECKED					

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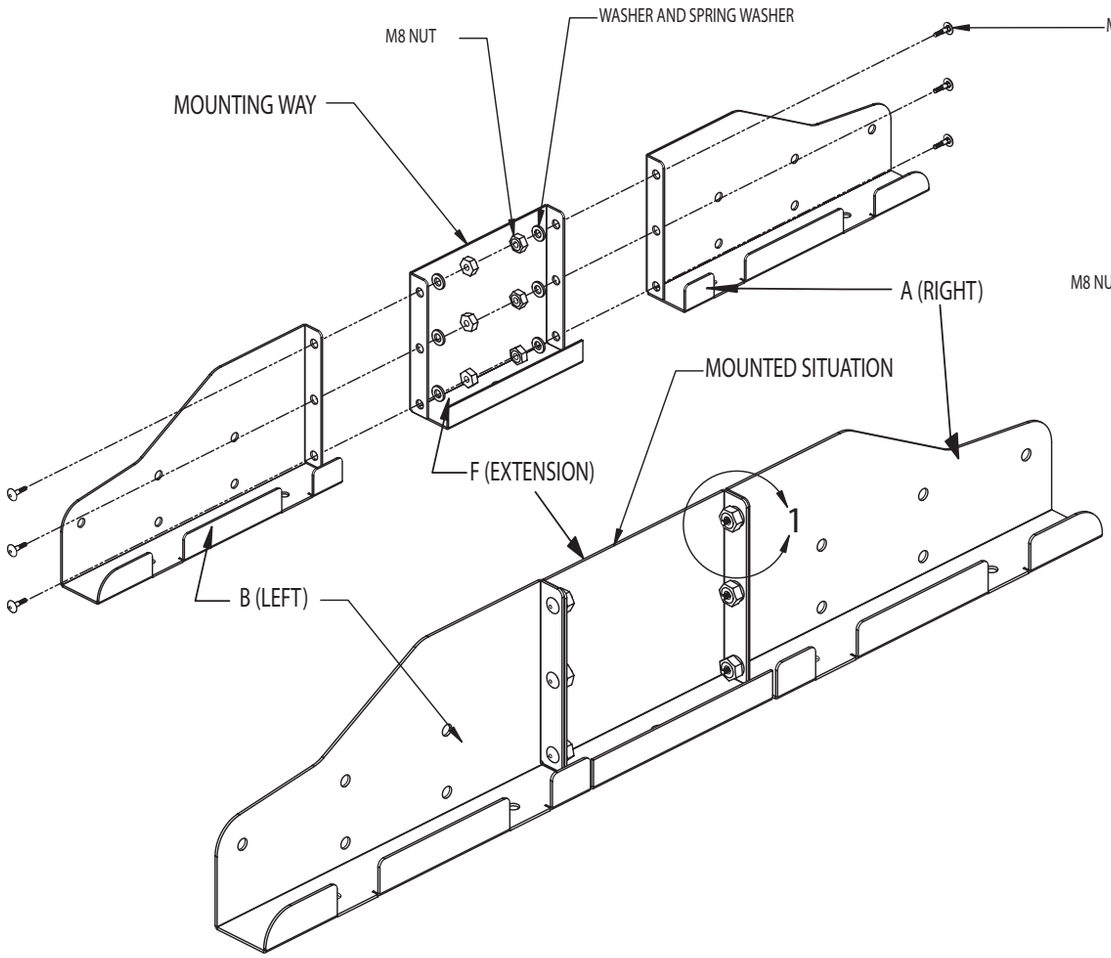
Step 1 — Assemble the Base



TOLERANCE						iSO 2768-m
Basic dimension		Deviation		Shorter side		Deviation
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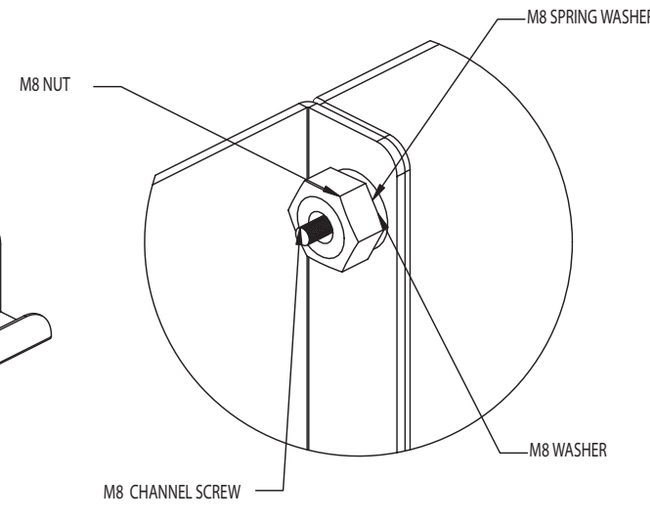
0.5	3	± 0.1	± 0.2	-	10°	± 1°
3	6	± 0.1	± 0.5	10°	50°	± 0°30'
6	30	± 0.2	± 1	50°	120°	± 0°20'
30	120	± 0.3	± 1	120°	400°	± 0°10'
120	400	± 0.5	± 1	400°	-	± 0°5'
400	1000	± 0.8	± 1			
1000	2000	± 1.2	± 1			



DETAIL 1
SCALE 2 : 1.5

1) Join one piece of right base A with one piece of extension kit F and left base B using the M8X15 screws, washers, spring washers and nuts as shown in Detail 1. Repeat the process for the other set of A, B & F.

REV				
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ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	QTY. REQD.
PARTS LIST				
MATERIAL: CRS1110 (A1)	FINISH			
CAD-GENERATED DRAWING DO NOT MANUALLY UPDATE		DOUBLE FRAME RELAY RACK ASSEMBLY INSTRUCTION		
DO NOT SCALE DRAWING				
APPROVALS	DATE	SIZE	DWG NO	SHEET OF
DRAWN			STEP_1	REV 00
CHECKED				

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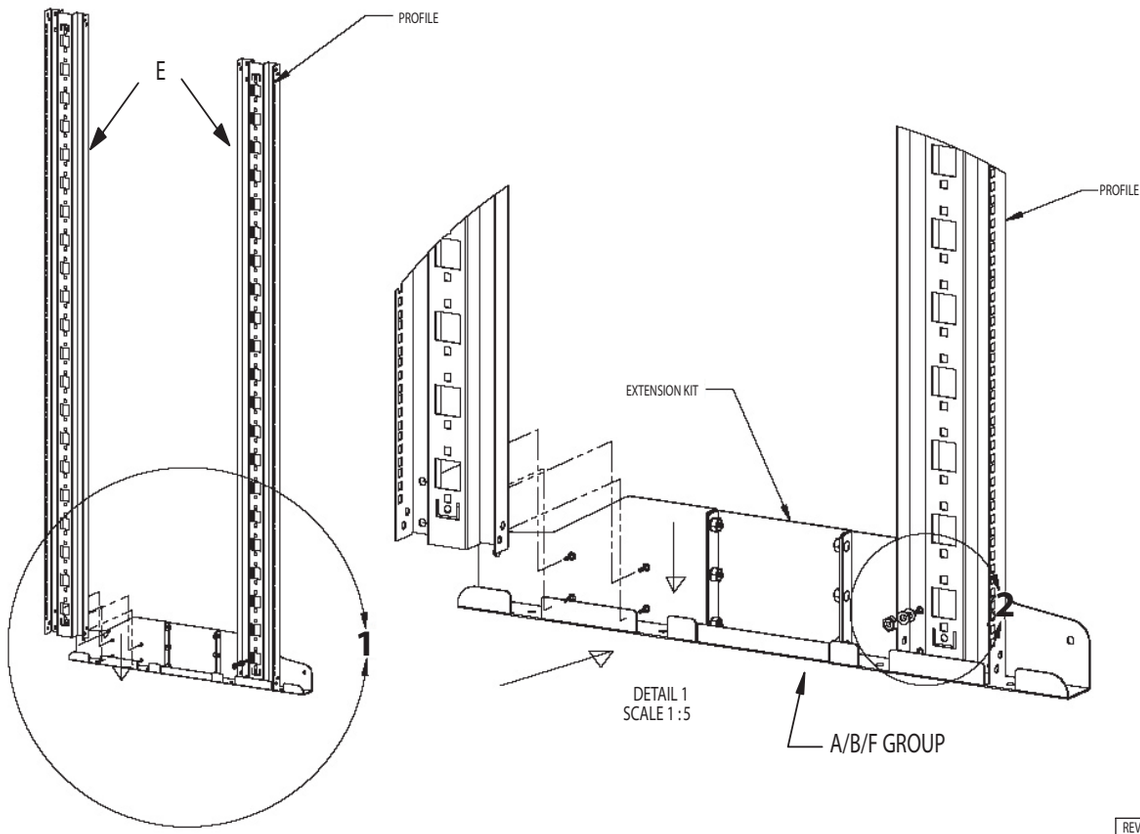
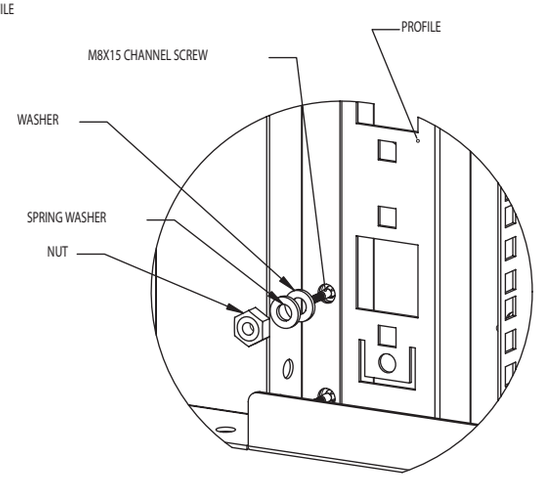
Step 2 — Assemble the Left and Right Side Vertical Rail Racks

LEFT AND RIGHT BASE GROUP





DETAIL 2
SCALE 1 : 2

TOLERANCE						iSO 2768-m
Basic dimension		Deviation		Shorter side		Deviation
<	>=	Liner dim.	Broken edges	<	>=	Degrees
0.5	3	± 0.1	± 0.2	-	10°	± 1°
3	6	± 0.1	± 0.5	10°	50°	± 0°30'
6	30	± 0.2	± 1	50°	120°	± 0°20'
30	120	± 0.3	± 1	120°	400°	± 0°10'
120	400	± 0.5	± 1	400°	-	± 0°5'
400	1000	± 0.8	± 1			
1000	2000	± 1.2	± 1			

1) Join the two left-side vertical rack rails (E) with the left base group (A/B/F) using the M8x15 screws, washers, spring washers and nuts as shown in Details 1 & 2. The square mounting holes should face out as shown in Detail 1. Repeat the process for the right-side vertical rack rails.

REV				
00				
ITEM NO	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION.	MATERIAL SPECIFICATION	QTY RQD
PARTS LIST				
MATERIAL: CRS1110 (A1)	FINISH			
CAD GENERATED DRAWING DO NOT MANUALLY UPDATE		DOUBLE FRAME RELAY RACK ASSEMBLY INSTRUCTION		
DO NOT SCALE DRAWING				
APPROVALS	DATE	SIZE	DWG NO	SHEET OF
DRAWN:			STEP_2	REV 00
CHECKED:				

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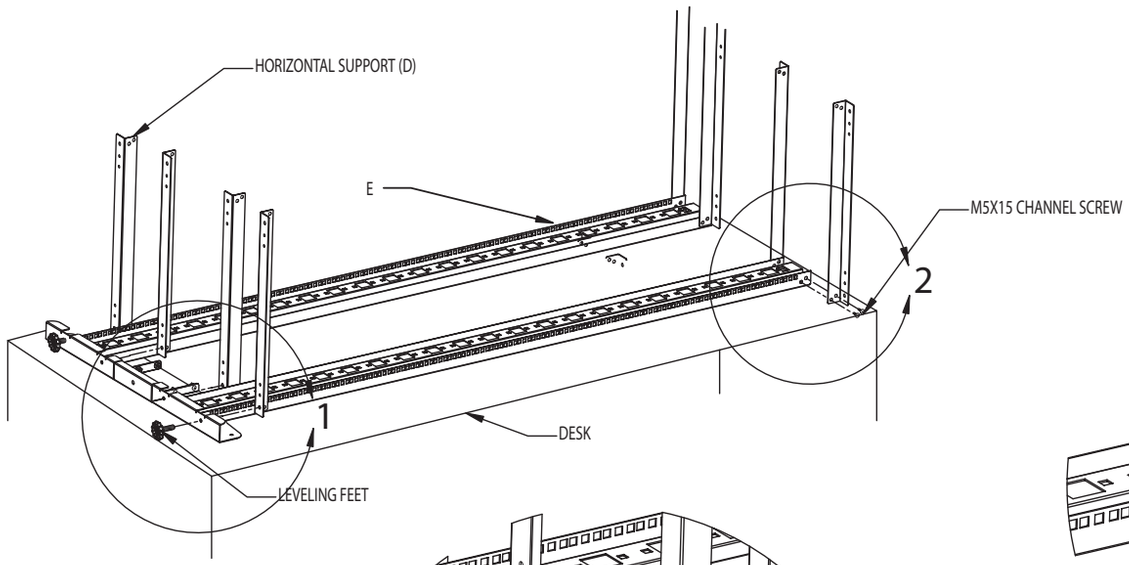
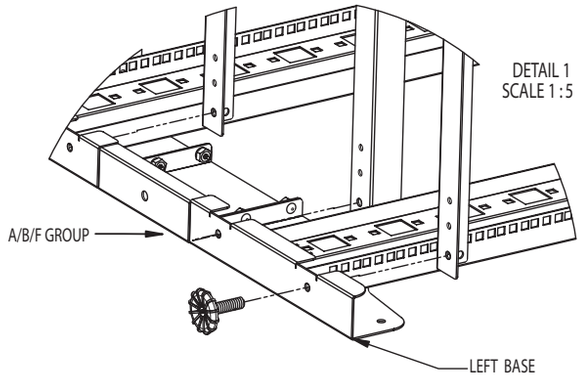
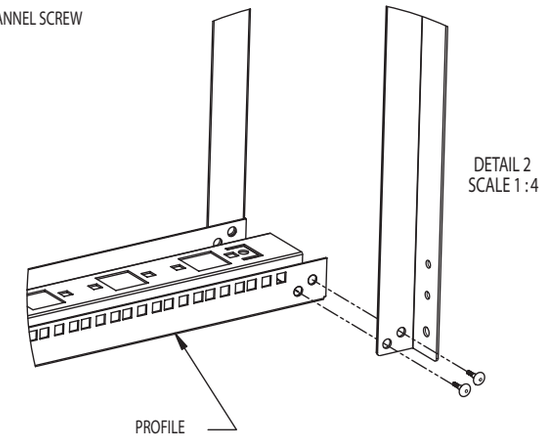
Step 3 — Assemble the Horizontal Support Rails







TOLERANCE						iSO 2768-m
Basic dimension		Deviation		Shorter side		Deviation
<	> =	Liner dim.	Broken edges	<	> =	Degrees
0.5	3	± 0.1	± 0.2	-	10°	± 1°
3	6	± 0.1	± 0.5	10°	50°	± 0°30'
6	30	± 0.2	± 1	50°	120°	± 0°20'
30	120	± 0.3	± 1	120°	400°	± 0°10'
120	400	± 0.5	± 1	400°	-	± 0°5'
400	1000	± 0.8	± 1			
1000	2000	± 1.2	± 1			

1) Attach four horizontal support rails (D) to the bottom right-side rack assembly using the M8x15 screws, washers, spring washers and nuts as shown in Detail 1.

2) Attach the leveling feet to the bottom of the rack assembly using the M8 washer and nut as shown in Detail 1.

3) Attach four horizontal support rails (D) to the top right-side rack assembly using the M8x15 screws, washers, spring washers and nuts as shown in Detail 2.

REV				
00				
ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	QTY. RQD.
PARTS LIST				
MATERIAL: CRS1110 (A1)	FINISH			
CAD-GENERATED DRAWING DO NOT MANUALLY UPDATE		DOUBLE FRAME RELAY RACK ASSEMBLY INSTRUCTION		
DO NOT SCALE DRAWING				
APPROVALS	DATE	SIZE	DWG NO	SHEET OF
DRAWN:			STEP_3	REV 00
CHECKED:				

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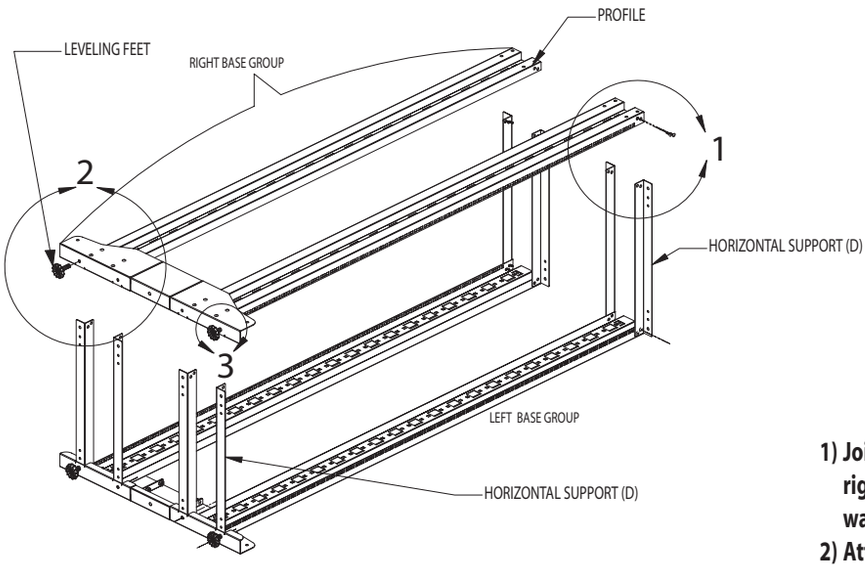
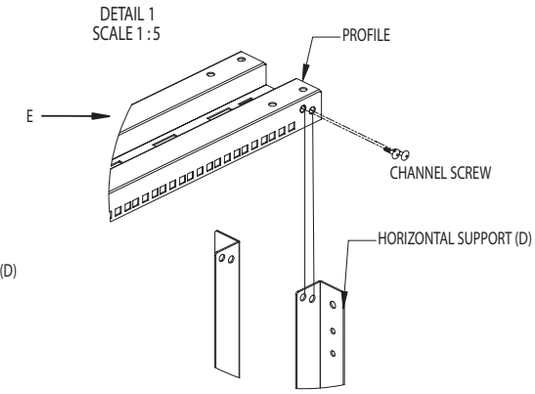
Step 4 — Assemble the Open Rack





TOLERANCE						iSO 2768-m
Basic dimension		Deviation		Shorter side		Deviation
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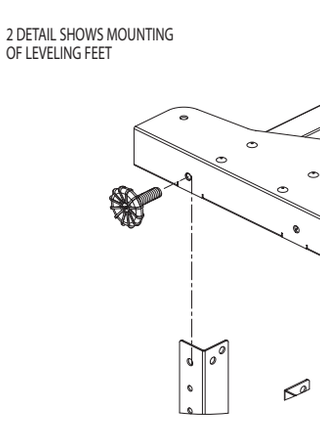
0.5	3	± 0.1	± 0.2	-	10°	± 1°
3	6	± 0.1	± 0.5	10°	50°	± 0°30'
6	30	± 0.2	± 1	50°	120°	± 0°20'
30	120	± 0.3	± 1	120°	400°	± 0°10'
120	400	± 0.5	± 1	400°	-	± 0°5'
400	1000	± 0.8	± 1			
1000	2000	± 1.2	± 1			

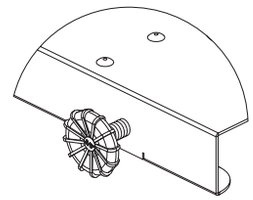
1) Join the left-side rack assembly to the right-side rack assembly by attaching the right-side support rails to the left using the M8x15 screws, washers, spring washers and nuts as shown in Details 1 & 2.

2) Attach the leveling feet to the bottom of the left-side rack assembly using the M8 washer and nut as shown in Detail 3.

3) Stand the rack upright on the leveling feet and firmly tighten all nuts and bolts.



DETAIL 2
SCALE 1 : 5



DETAIL 3
SCALE 1 : 3

REV				
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ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	QTY. RQD.
PARTS LIST				
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CAD-GENERATED DRAWING DO NOT MANUALLY UPDATE		DOUBLE FRAME RELAY RACK ASSEMBLY INSTRUCTION		
DO NOT SCALE DRAWING				
APPROVALS	DATE	SIZE	DWG NO	SHEET OF
DRAWN			STEP_4	REV 00
CHECKED				

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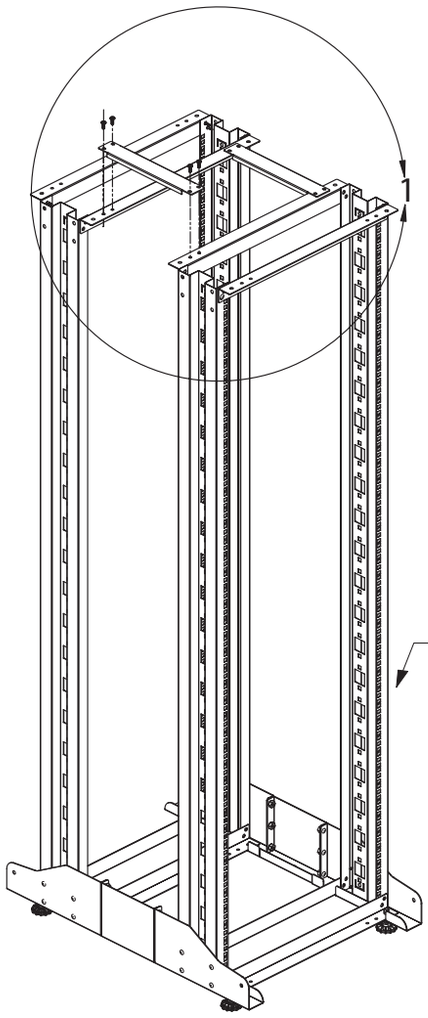
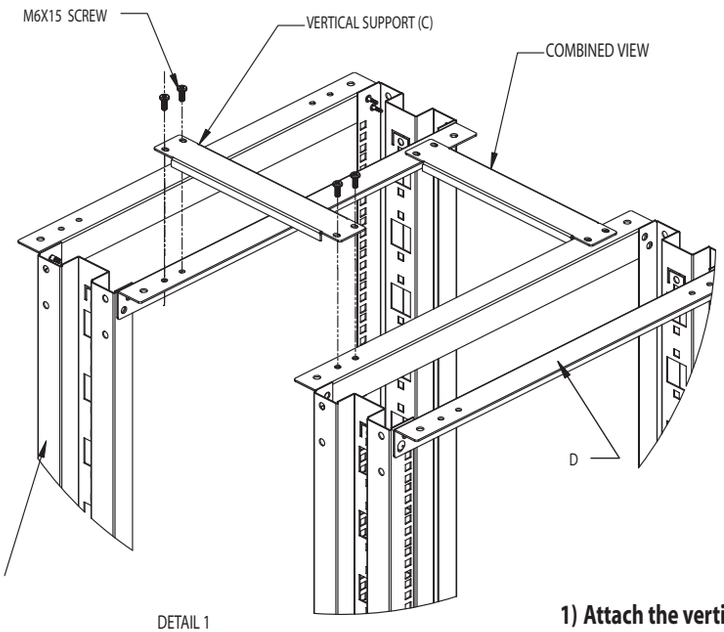
Step 5 — Attach the Vertical Support Rails





DETAIL 1
SCALE 1 : 5

TOLERANCE						iSO 2768-m
Basic dimension		Deviation		Shorter side		Deviation
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0.5	3	± 0.1	± 0.2	-	10°	± 1°
3	6	± 0.1	± 0.5	10°	50°	± 0°30'
6	30	± 0.2	± 1	50°	120°	± 0°20'
30	120	± 0.3	± 1	120°	400°	± 0°10'
120	400	± 0.5	± 1	400°	-	± 0°5'
400	1000	± 0.8	± 1			
1000	2000	± 1.2	± 1			

1) Attach the vertical supports rails (C) to the top of the rack by using the M6x15 screws, washers, spring washers and nuts as shown in Detail 1.

REV				
00				
ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	QTY. RQD.
PARTS LIST				
MATERIAL: CRS1110 (A1)	FINISH			
CAD-GENERATED DRAWING DO NOT MANUALLY UPDATE		DOUBLE FRAME RELAY RACK ASSEMBLY INSTRUCTION		
DO NOT SCALE DRAWING				
APPROVALS	DATE	SIZE	DWG NO	SHEET OF
DRAWN:			STEP_5	REV 00
CHECKED:				

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with comments or questions.

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